

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009459**Date Inspected:** 25-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming, Du Zhi Qun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY # 10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 3A located on PCMK SSTL4-1B/L. Welder is identified as 053869 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-C-U2-F.

SMAW welding process of weld joint 4A located on PCMK SSTL4-1B/L. Welder is identified as 057220 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2.

FCAW welding process of weld joint 79 located on PCMK NSD1-FDSA4-3C/D. Welder is identified as 057180 ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

FCAW welding process of weld joint 68 located on PCMK NSD1-FDSA4-3C/D. Welder is identified as 052075 ZPMC QC is identified as Du Zhi Qun. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-4332-TC-P5-F.

BAY # 11

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 80 located on PCMK WSTL3-4B/K. Welder is identified as 042218 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

FCAW welding process of weld joint 14 located on PCMK WSTL3-4K/K. Welder is identified as 070254 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-B-U2A-F.

FCAW welding process of weld joint 77 located on PCMK WSTL3-4B/K. Welder is identified as 040713 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

FCAW welding process of weld joint 78 located on PCMK WSTL3-4B/K. Welder is identified as 046706 ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

BAY#14

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 004 located on PCMK SEG072A. Welder is identified as 214945 ZPMC QC is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F.

SAW welding process of weld joint 032 located on SEG056* . Welder is identified as 058100 ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-2.

SMAW welding process of weld joint 029 located on PCMK EP147-001. Welder is identified as 440779 ZPMC QC is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant
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Quality Assurance Inspector

Reviewed By:	Dawson,Paul
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QA Reviewer
